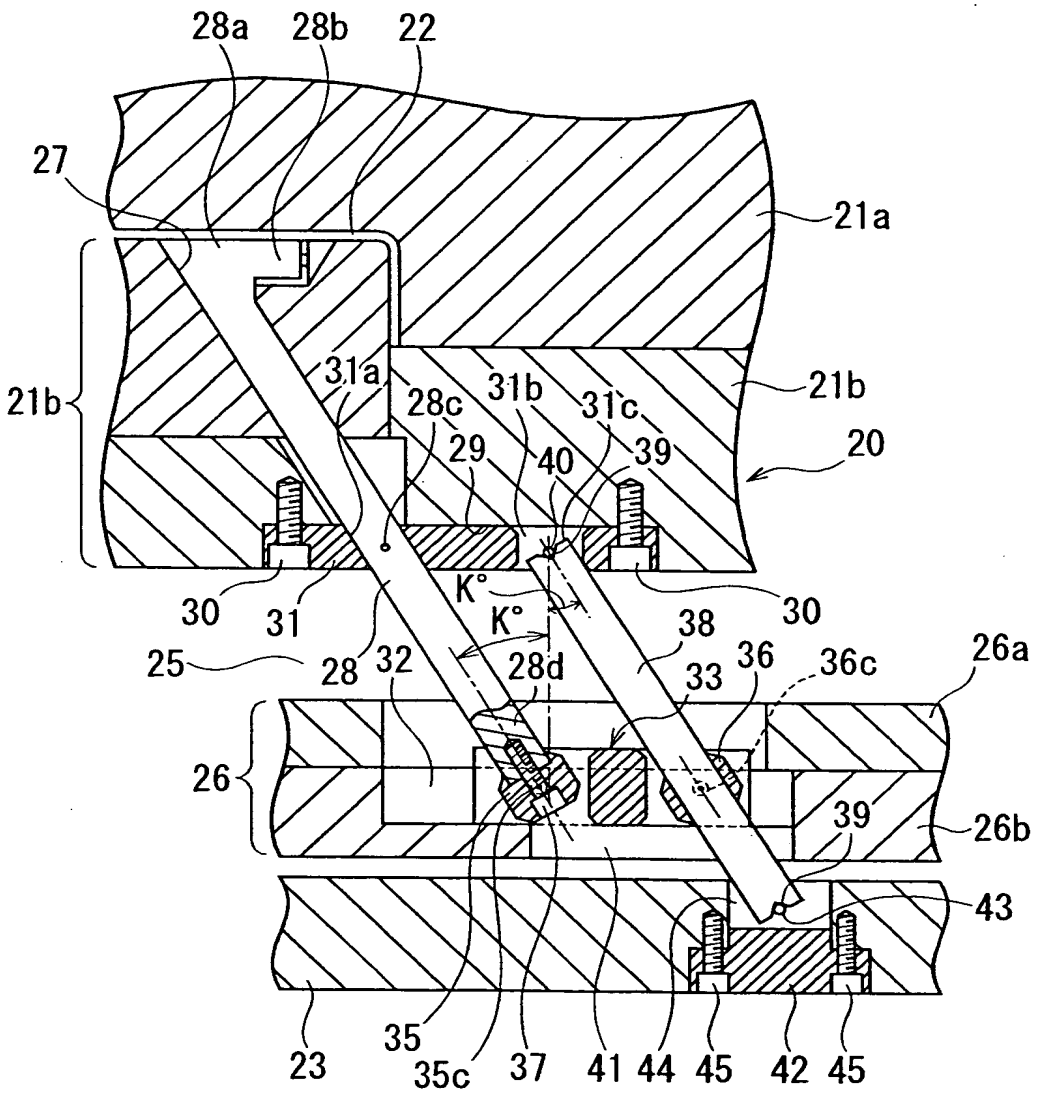

28a
28b
22
27
21a
21b
21b
31a
28c
31b
31c
29
40
39
20
30
31
K°
K°
30
25
28
32
28d
38
33
36
36c
26a
26
39
26b
43
23
35
35c
37
41
44
45
42
45

Fig. 1

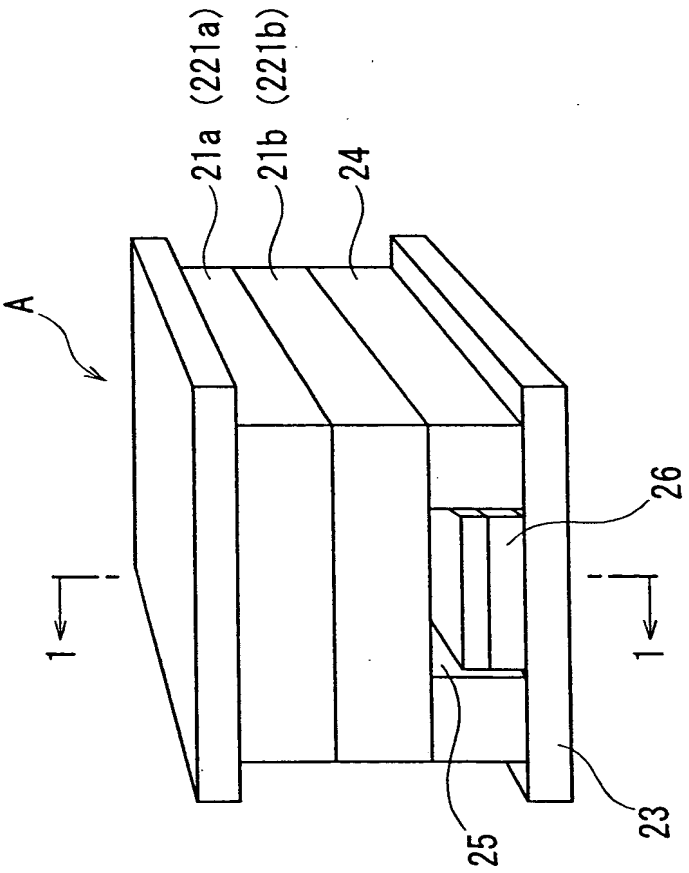


Fig. 2

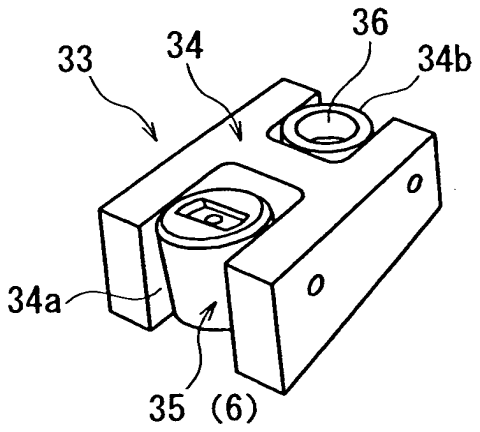


Fig. 3

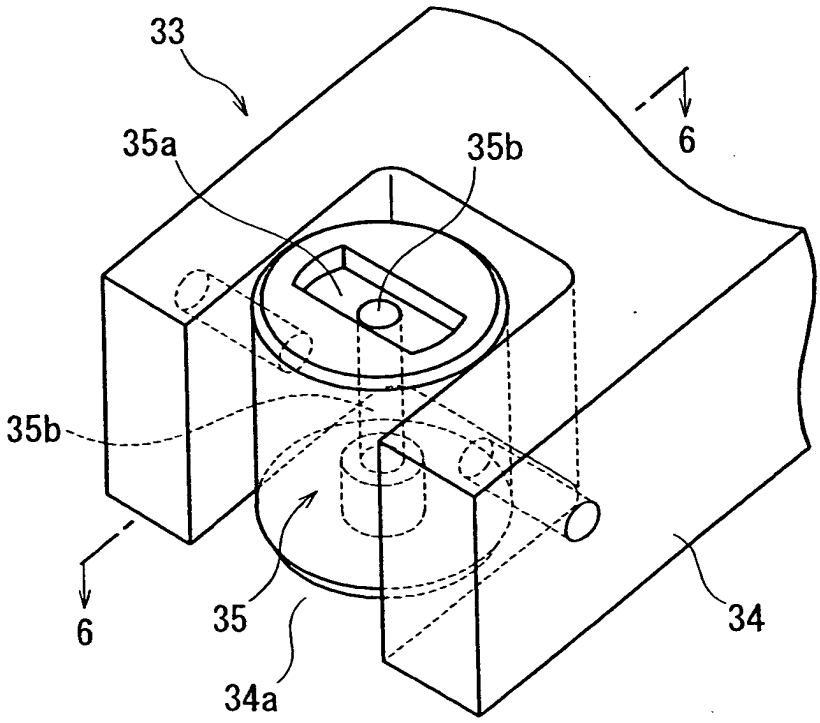


Fig. 4

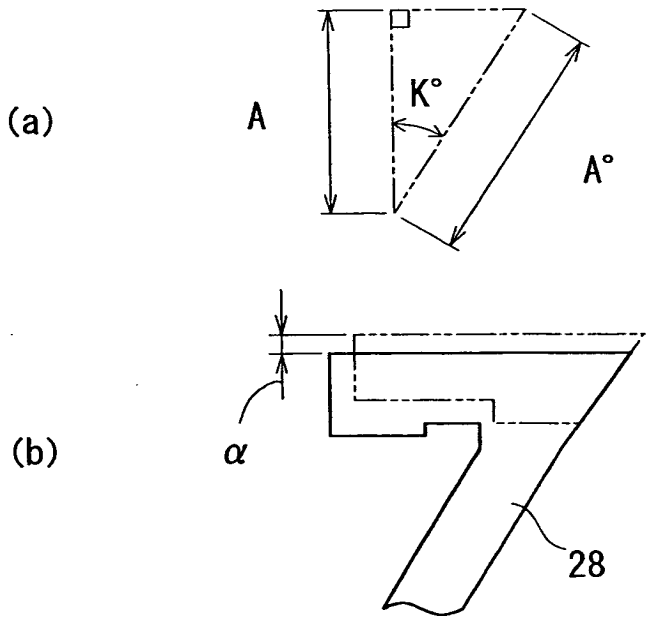


Fig. 5

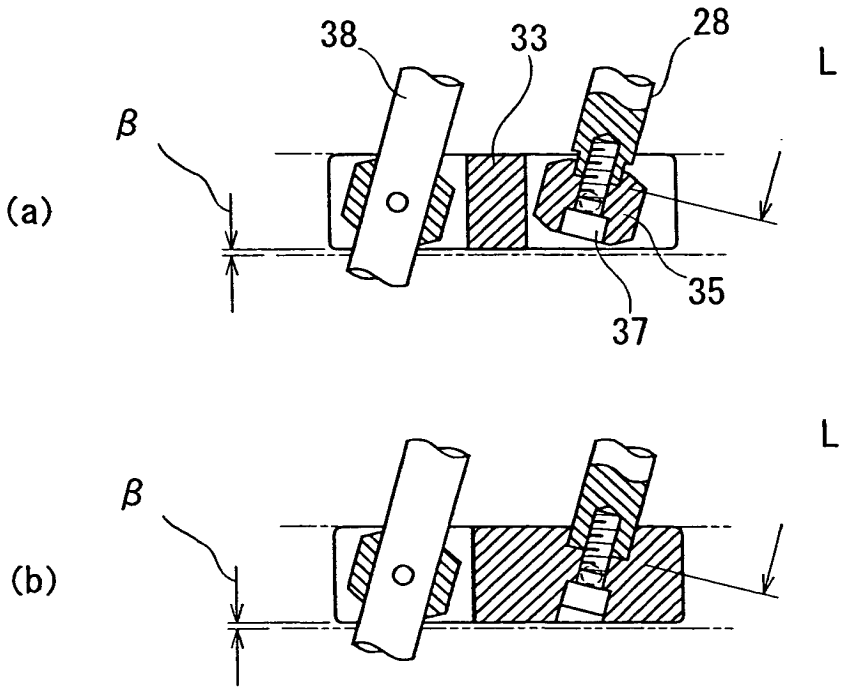


Fig. 6

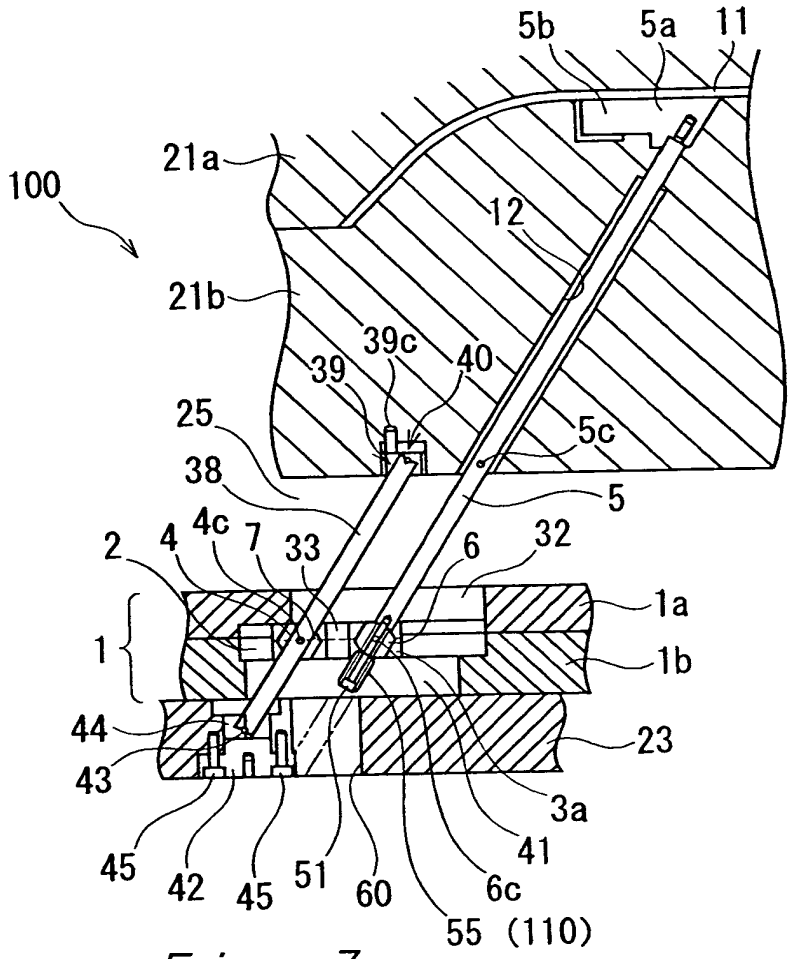

5b
5a
11
21a
100
12
21b
39c
40
39
25
5c
38
5
2
4
4c
7
33
6
32
1a
1
1b
44
23
43
3a
41
45
42
45
51
60
6c
55 (110)

Fig. 7

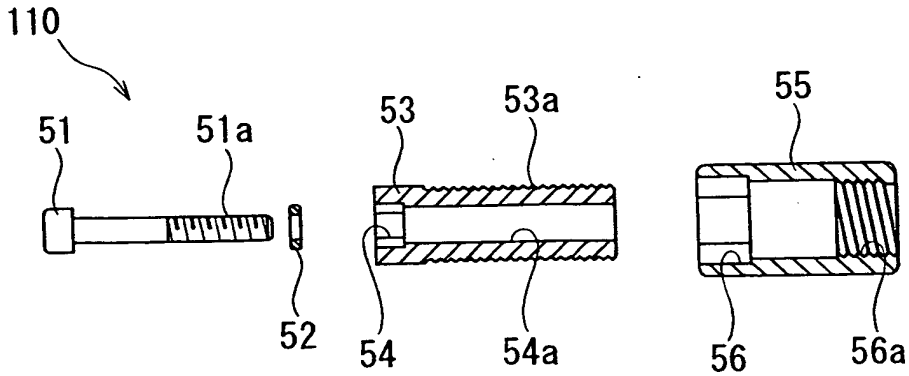

110
51
51a
53
53a
55
52
54
54a
56
56a

Fig. 8

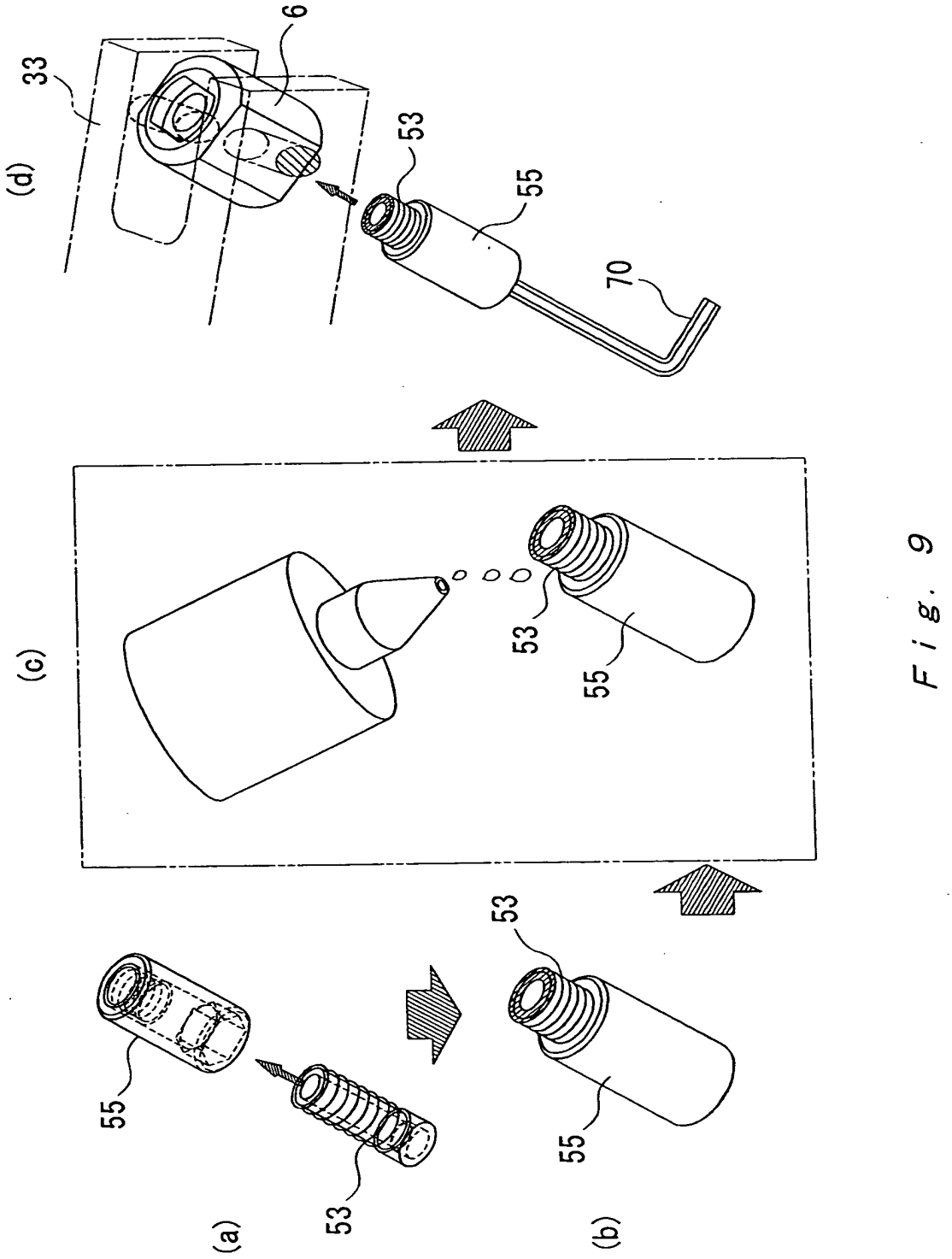


Fig. 9

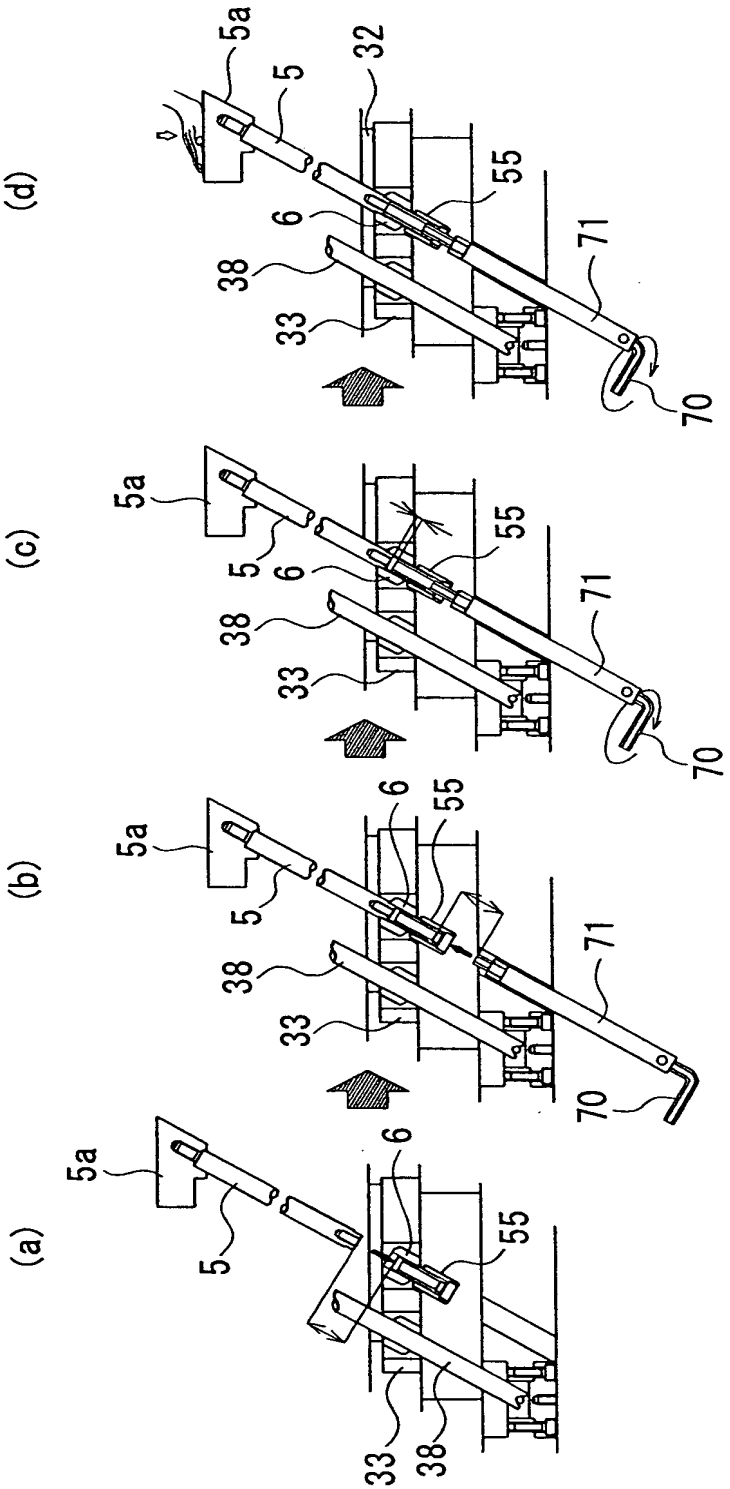
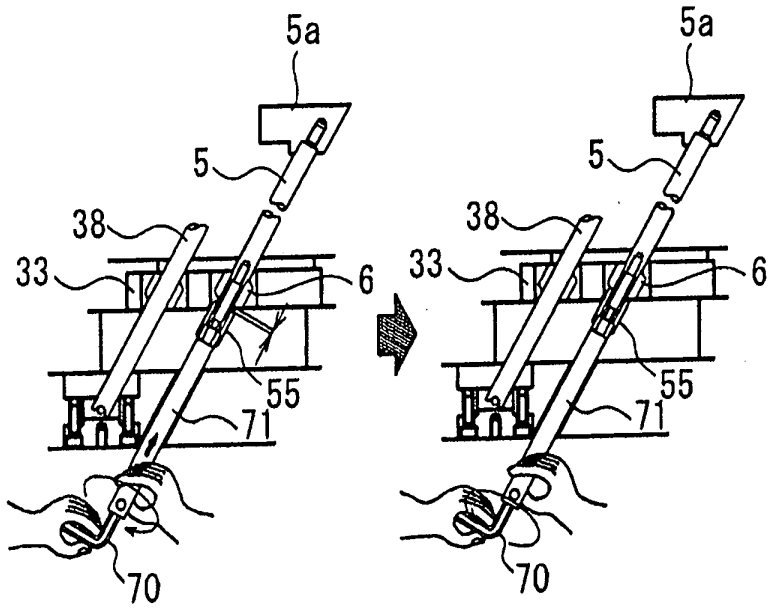


Fig. 10

(a) (b)



(c)

Adjusting screw return angle and clearance setting amount				
Adjusting screw		Screw thread pitch	45°	90°
M	M8	1.0	0.13	0.25
L	M12	1.5	0.2	0.38
LL	M14	1.5	0.2	0.38
EL	M18	2.0	0.3	0.5
FL	M22	2.0	0.3	0.5

Calculation example for evaluating thermal expansion of core-rod/bar

Length of core-rod/bar; 600mm

Average temperature rise; 20 to 30°C

Coefficient of linear expansion; 1.2×10^{-5}

Thermal expansion; $600 \times (20 \text{ to } 30) \times 1.2 \times 10^{-5} = 0.14 \text{ to } 0.22$

Example of adjustment of thermal expansion of core-rod/bar;

In the case of LLS-LL, from the

LL	M14	1.5	0.2	0.38

section of the above table, the return amount and the reversing angle for the adjusting screw are 0.2 and 45°, respectively.

Fig. 11

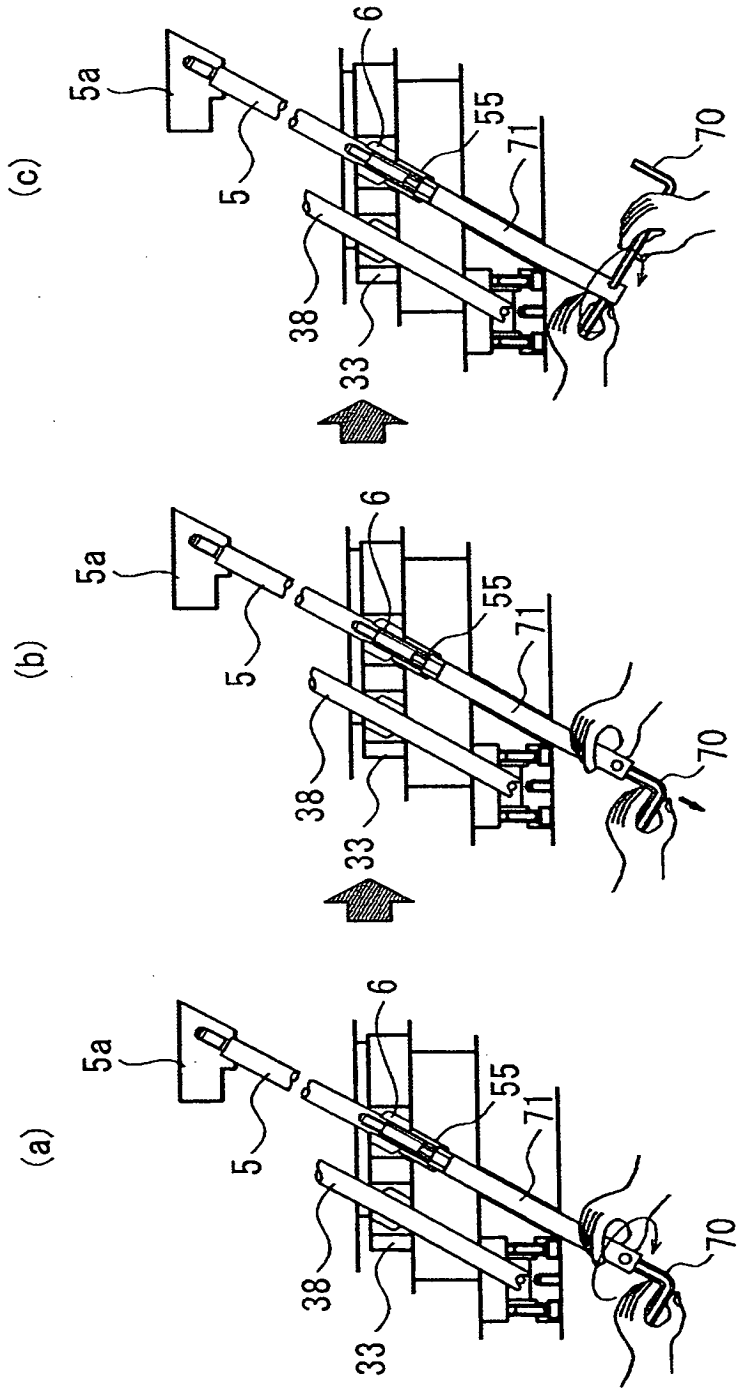


Fig. 12

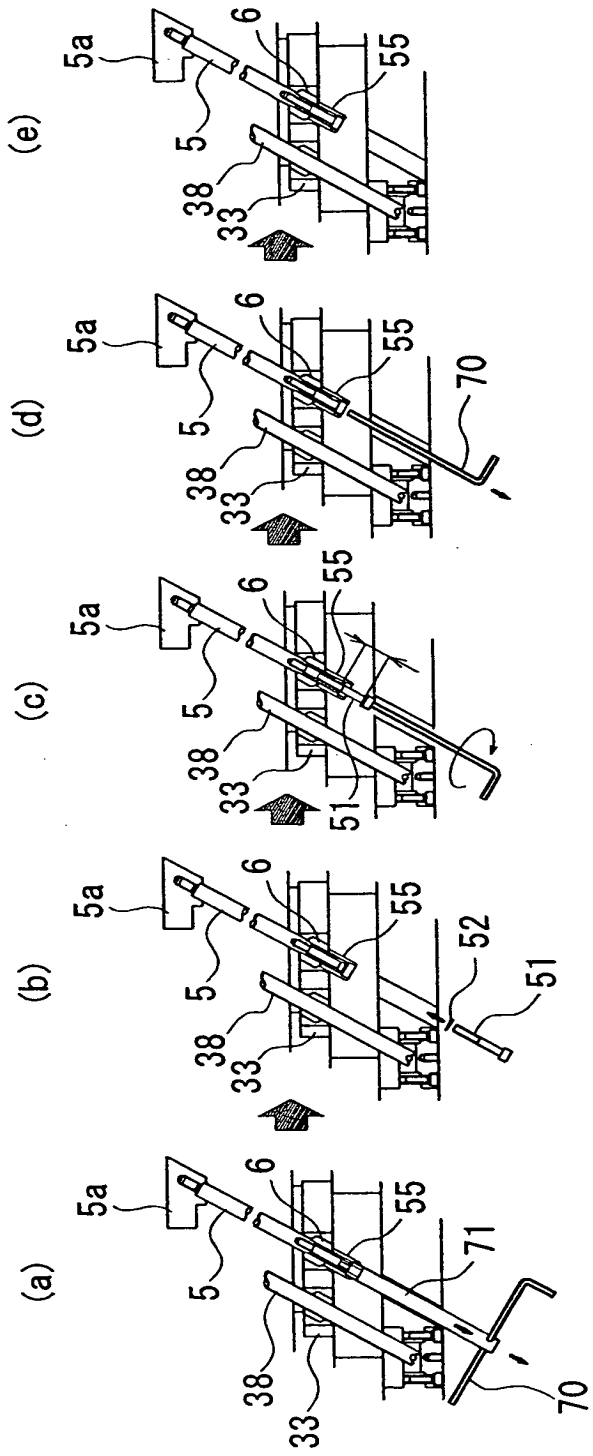

(e)
5a
6
55
5
38
33
(d)
5a
6
55
70
5
38
33
(c)
5a
6
55
5
38
33
51
(b)
5a
6
55
52
51
5
38
33
(a)
5a
6
55
71
5
38
33
70

Fig. 13

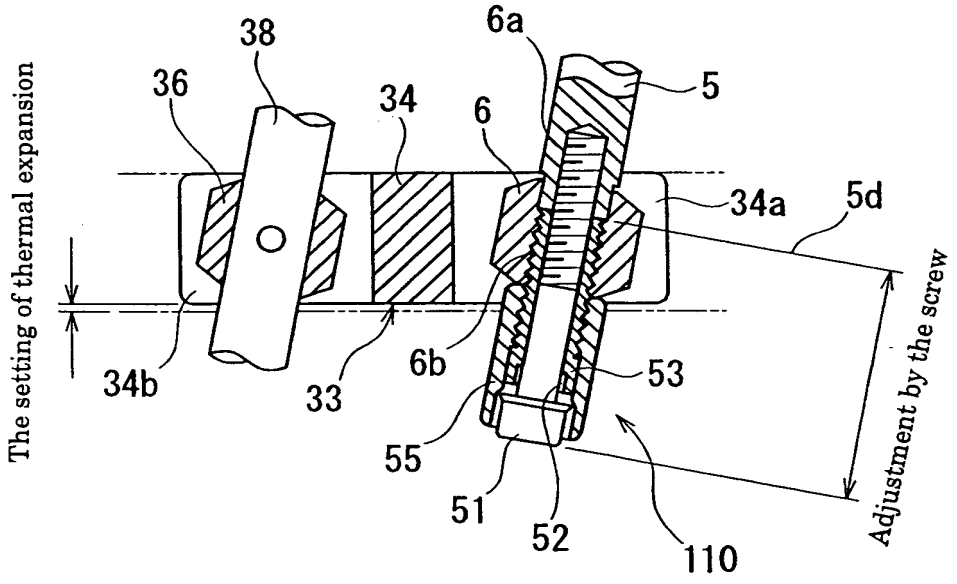

38
6a
36
34
6
5
34a
5d
The setting of thermal expansion
34b
33
6b
53
55
51
52
110
Adjustment by the screw

Fig. 14

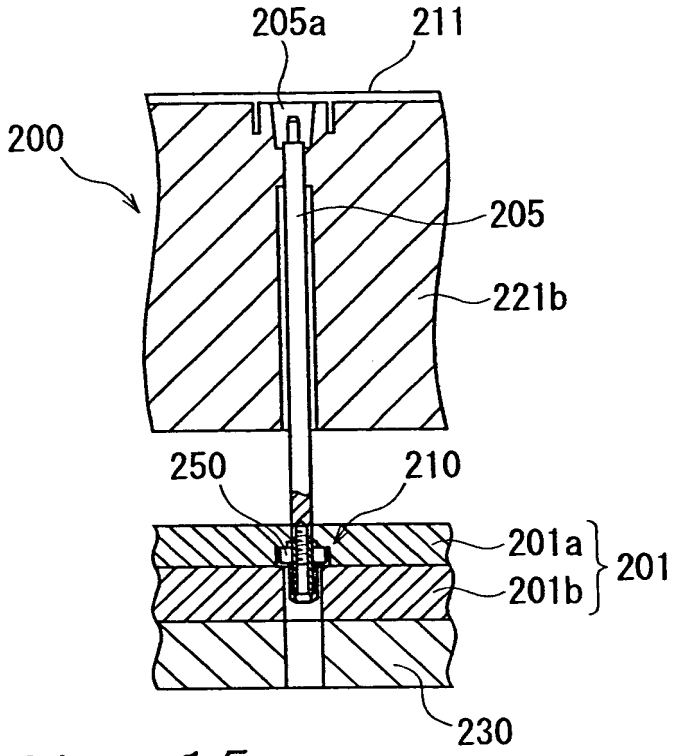

205a
211
200
205
221b
250
210
201a
201b
201
230

Fig. 15

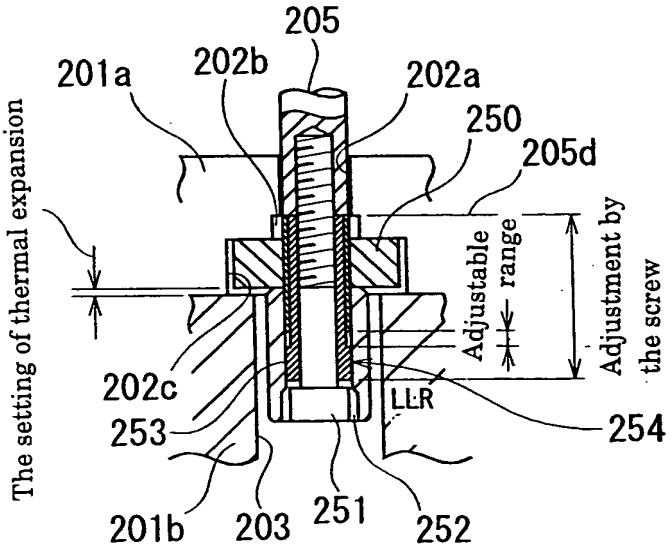

205
201a
202b
202a
250
205d
The setting of thermal expansion
Adjustable range
Adjustment by the screw
202c
LLR
253
254
201b
203
251
252

Fig. 16

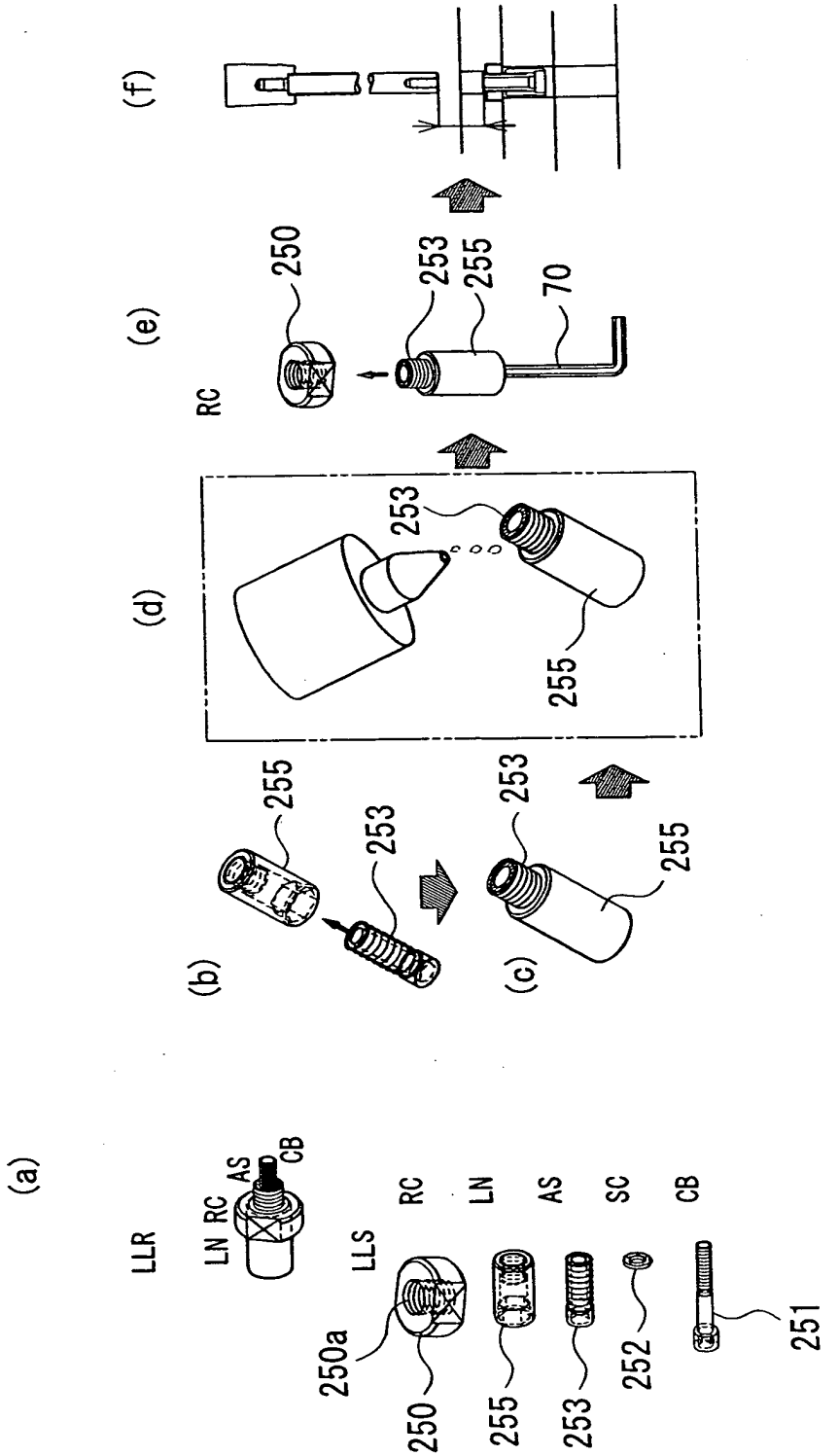

(a)
LLR
LN RC AS CB
LLS
RC
LN
AS
SC
CB
250a
250
255
253
252
251
(b)
255
253
(c)
253
255
(d)
253
255
(e)
RC
250
253
255
70
(f)

Fig. 17

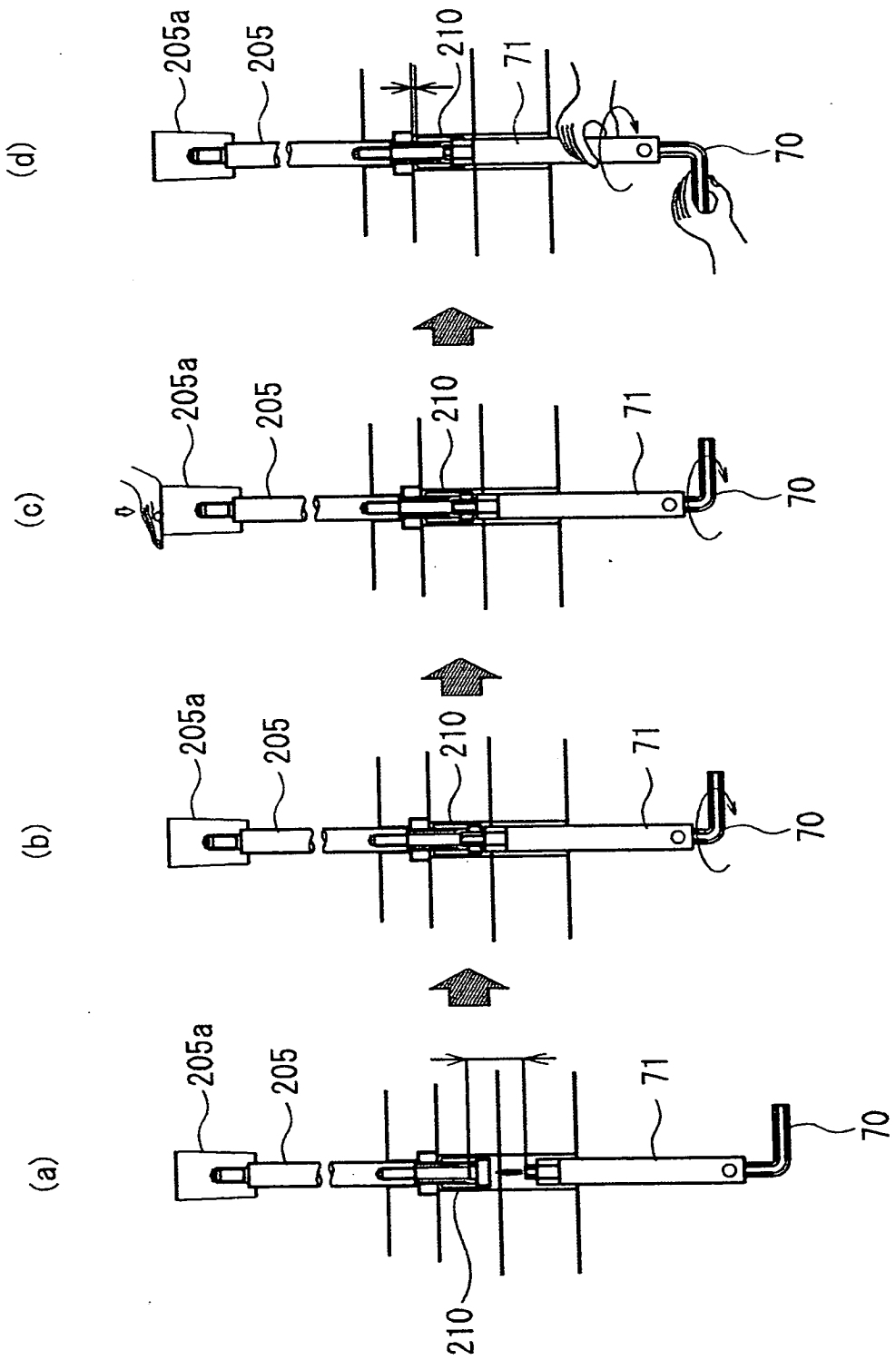


Fig. 18

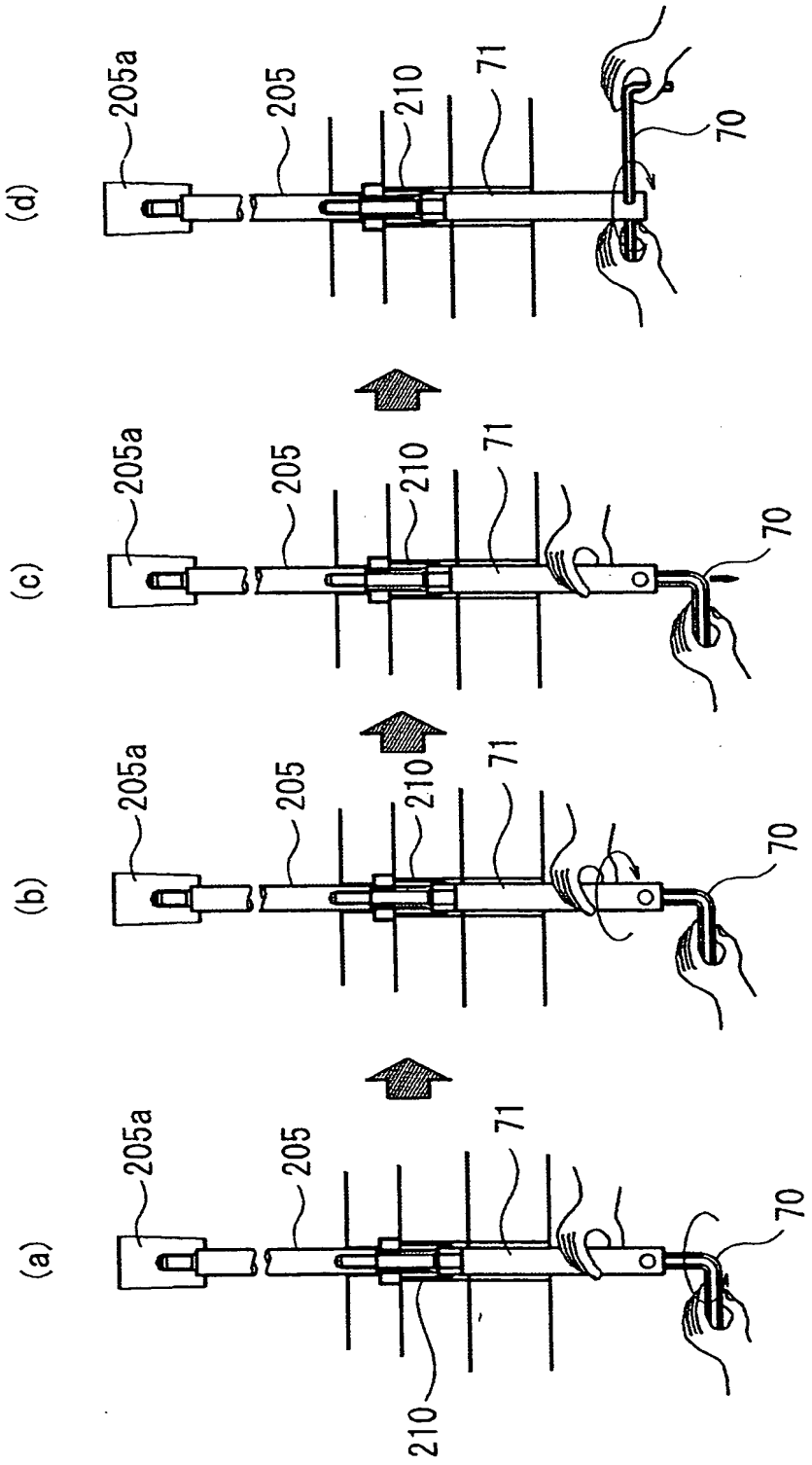


Fig. 19

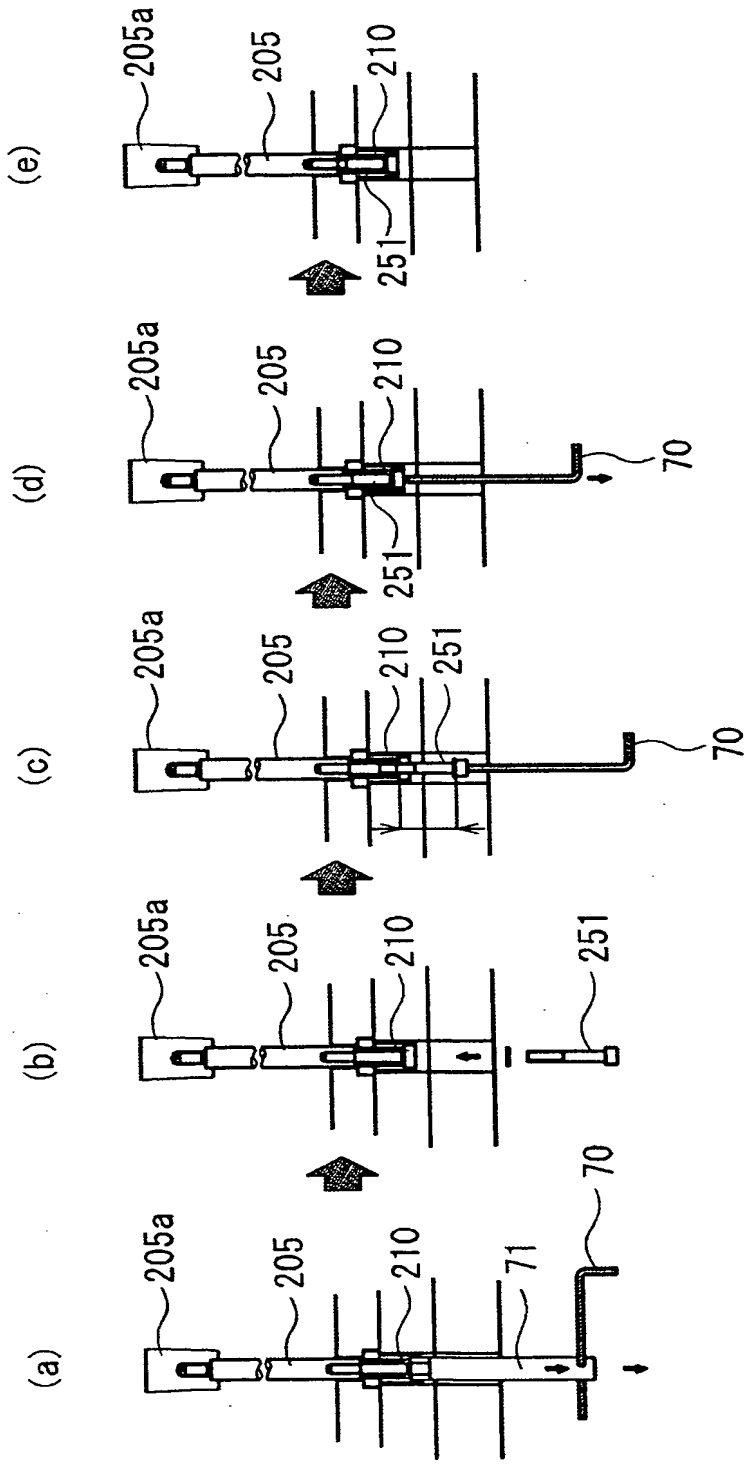

(a)
205a
205
210
71
70
(b)
205a
205
210
251
(c)
205a
205
210
251
70
(d)
205a
205
210
251
70
(e)
205a
205
210
251

Fig. 20

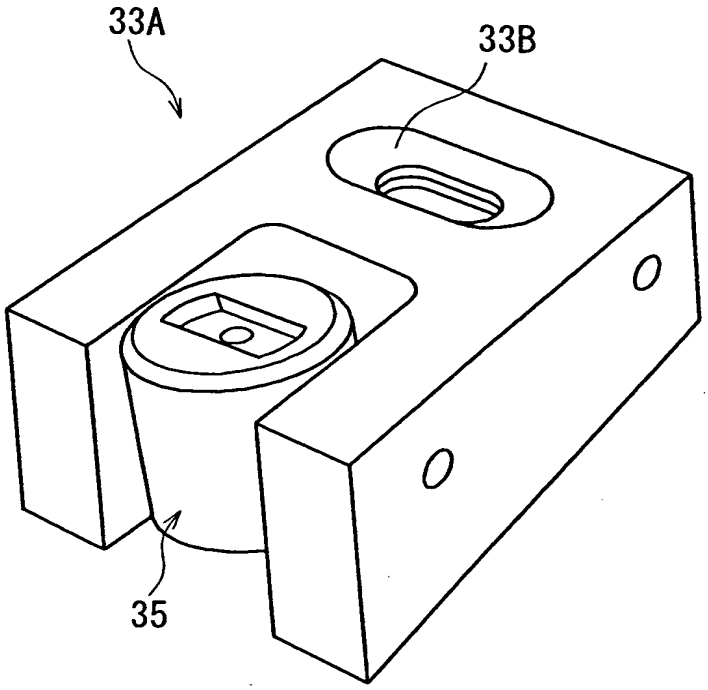


Fig. 21